

Date: Wednesday, 10/11/2006 12:50:42 PM  
 User: Kim Johnston

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : STEM  
 Job Number : 28945  
 Estimate Number : 10857  
 P.O. Number : N/A Part Number : D34073  
 This Issue : 10/11/2006 S.O. No. : N/A Drawing Number : D3407 REV C  
 Prsht Rev. : NC Project Number : N/A  
 First Issue : N/A Type : MACHINED PARTS Drawing Revision : C  
 Previous Run : 24888 Material : N/A  
 Due Date : 10/30/2006 Qty: 12 Um: Each  
 Written By :  
 Checked & Approved By : JF 06.10.11  
 Comment : Est Rev:A 06.10.18 New issue KJ/EC

## Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M174R0750 Inventory



Comment: Qty.: 0.3843 f(s)/Unit Total : 4.6116 f(s)  
 Material: 17-4ph SS Round Bar Ø0.750(M17-4-R0.750)  
 Identify for D3407-3  
 Batch: ~~M106891~~ 100841

MS 06/10/28

(20)

2.0 HARDINGE HARDINGE CNC LATHE SMALL



Comment: HARDINGE CNC LATHE SMALL

1-Turn as per Folio FA597 Rev: AA & Dwg D3407 Rev: C

2-Deburr

JF MS 06/10/28

(20)

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

JF 06/10/28

(20)

4.0 HAAS1 HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1

1- Machine as per Folio FA597 and Dwg D3407

2-Deburr

J.F. 06/11/06

(20)

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☐ No ☒ DQA:      Date: 06/11/07  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Wednesday, 10/11/2006 12:50:42 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STEM

Job Number: 28945

Part Number: D34073

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

J.F. 06/11/06 20

6.0

QC8

SECOND CHECK



Comment: SECOND CHECK

SD 06.11.06

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

57432

FINAL INSPECTION/W/O RELEASE

06/11/07

(20)

8.0

QC21



Comment: FINAL INSPECTION/W/O RELEASE

SD 06/11/07

Job Completion



U 06-11-07

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

DART AEROSPACE LTD		Work Order: 28445
Description: STEM		Part Number: 03407-3
Inspection Dwg:	Rev: C	Page 1 of 1

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☒ Prototype

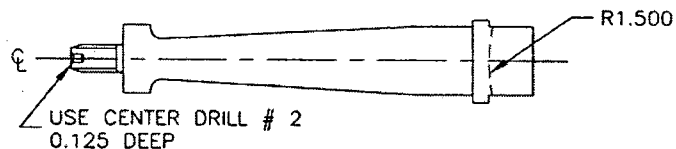
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
4.325"	±.010"	4.326"	✓			
3.305"	±.010"	3.301"	✓			
2.555"	±.010"	2.545"	✓			
.250"	±.010"	.245"	✓			
.063"	±.010"	.063"	✓			
.470"	±.010"	.464"	✓			
.500"	±.010"	.500"	✓			
.550"	±.010"	.548"	✓			
Ø.625"	±.010"	.623"	✓			
Ø.750"	±.010"	.748"	✓			
Ø.363"	±.010"	.365"	✓			
.250"	±.010"	.250"	✓			
.625"	±.010"	.628"	✓			
.150"	±.010"	.144"	✓			
R0.125	±.010"	R0.125"	✓			
1/4-28 UNF		1/4-28 UNF				

Measured by: J.F.I
Date: 06/10/28

Audited by: [Signature] SA
Date: 06.11.06

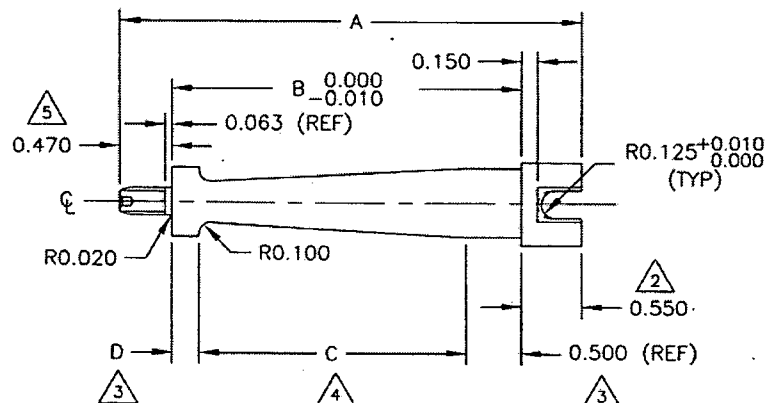
Prototype Approval: [Signature]
Date:

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	



RELEASED

05.09.12



PART NUMBER	A	B	C	D
D3407-1	5.270	4.250	3.250	0.500
D3407-3	4.325	3.305	2.555	0.250

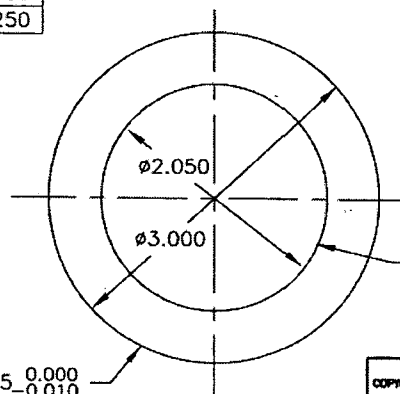
### D3407-1/-3 STEM

### D3407-1 AND D3407-3 STEM:

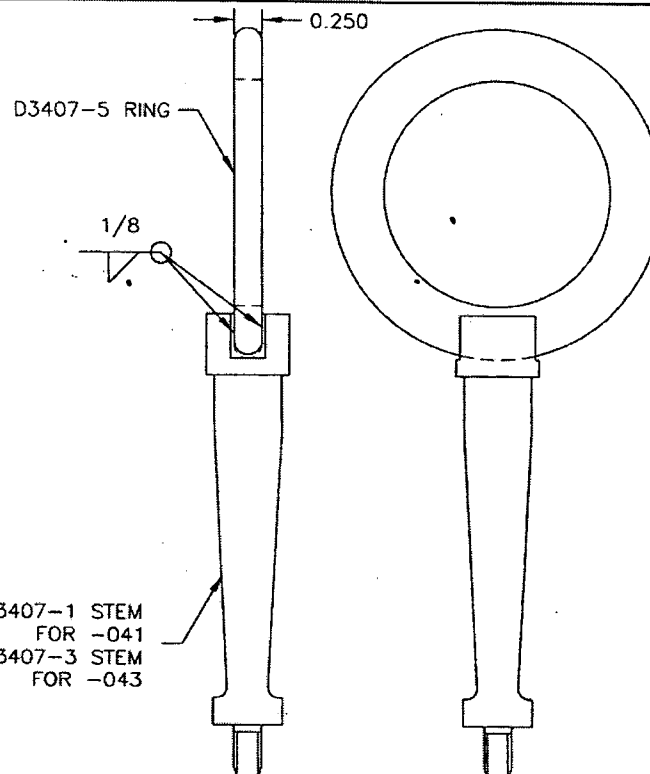
- 1) MATERIAL: 17-4 PH SS ROUND BAR (REF DART SPEC. M17-4-R0.750)
- 2)  $\phi 0.750$  O.D.
- 3)  $\phi 0.625$  O.D.
- 4) MACHINE UNIFORM TAPER FROM  $\phi 0.363$  O.D. TO  $\phi 0.625$  O.D.
- 5) 1/4-28 UNF THREAD WITH 0.063 GRIP, CLASS 2A
- 6) MACHINE ALL INSIDE EDGES WITH A 0.010 RADIUS
- 7) UNLESS OTHERWISE INDICATED
- 8) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

### D3407-5 RING:

- 9) MATERIAL 17-4 PH SS ROUND BAR (REF DART SPEC. M17-4-R3.000)
- 10) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED



### D3407-5 RING



USE D3407-1 STEM FOR -041  
USE D3407-3 STEM FOR -043

### D3407-041 AND D3407-043 TOW RING:

- 11) WELD PER QSI 004 ON ALL EDGES BETWEEN STEM AND RING
- 12) FINISH: POWDER COAT WHITE (REF 4.3.5.2) PER DART QSI 005 4.3 (EXCEPT THREADS)
- 14) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

DEBURR 0.010 TO 0.020

C	05.09.09	-1/-3 LONGER FOR FIT W/ WASHER
B	05.06.17	UPDATE DIAMETER, THREAD CLASS ADDED
A	05.03.16	NEW ISSUE
DESIGN	CP	DRAWN BY CP
CHECKED	CP	APPROVED
DATE	05.09.09	TOW RING
DRAWING NO.	D3407	REV. 0
TITLE	TOW RING	SHEET 1 OF 1
SCALE	1:1	

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